

Work Order ID 86483

86483

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June-29-12 1:31:46 PM

Item ID: D212-580-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Mirror Assembly, 8 inch Round

Start Date: 29/06/2012 Start Qty: 200

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 200

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/29 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2161	B2
IIN-D212-580-1	A

100 0.00

100

DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy bluefile and create labels as per PPP D212-580-041 CHG004

160 0.00

160

Pick Kit

Packaging

Memo

Packaging

0.00

DAS 16 12/06/12

MLJ 12/08/17

4x 50 12-7-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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June-29-12 1:31:46 PM

Item ID: D212-580-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Mirror Assembly, 8 inch Round

Start Date: 29/06/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212--580-041 Location: <u>4</u> PPP Rev: _____								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
16
9-89

12/6/15

XL

40

12/8/15 SP

MLJ 12/08/17

ME
12-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86483

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Parent Item: D212-580-041

D212-580-041

Parent Item Name: Cargo Mirror Assembly, 8 inch Round

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

IPP REV:I AS PER ECN10-611 10-09-07 JLM VERIFIED

BY:DD

IPP rev:J

10.11.22 AS PER ECN10-642 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3439-101		Manufactured	No			100	Each	0.0000	2	8			
D3439-101									**	B82773			
Mirror Assembly 8"													
D2161-212		Manufactured	No			100	Each	0.0000	1	21			
D2161-212									**	4x B85967			
Mirror Bracket, 212													
MS20426AD3-4		Purchased	No			100	Each	2,750.000	8	32			
MS20426AD3-4									**				
RIVET													

Location

Loc Qty

Loc Code

ST316

2750

104374

236

110398

2514

D4164-041

Manufactured

No

100

Each

60.0000

D4164-041

Nut Plate Adapter Assembly

Location

Loc Qty

Loc Code

ST104

60

82782

20

83422

40

12 3x
4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 86483

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Parent Item: D212-580-041

D212-580-041

Parent Item Name: Cargo Mirror Assembly, 8 inch Round

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-08

Purchased

No

100

Each

1,180.000



MS27039-1-08

Screw

m122452
SP12-7-26

Location

Loc Qty

Loc Code

ST291

1180

117423

81

119075

1

120308

166

121011

43

121243

500

121708

389

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

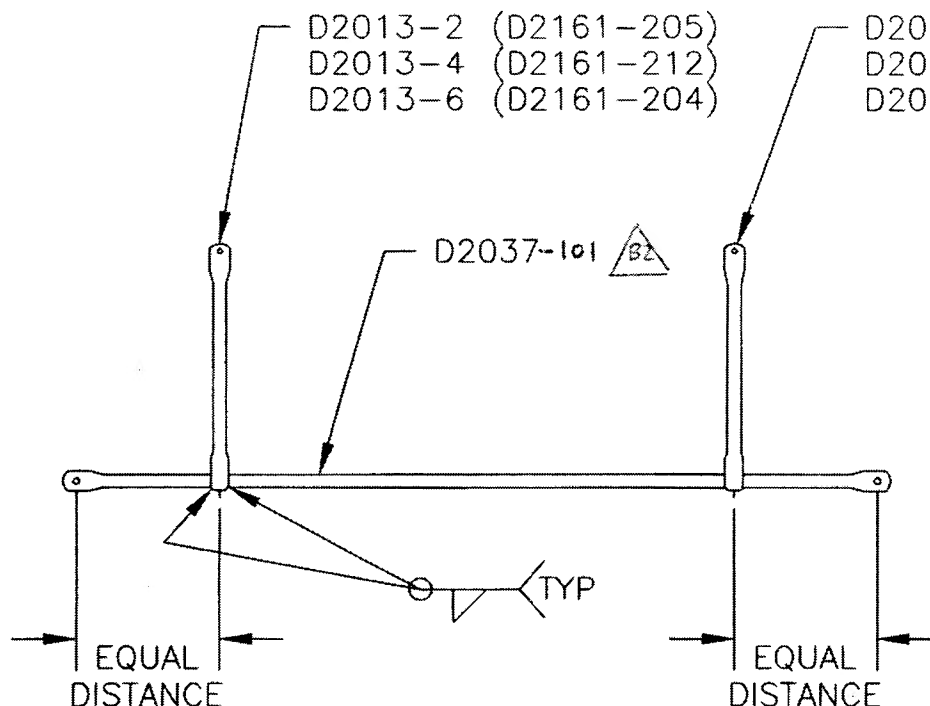
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

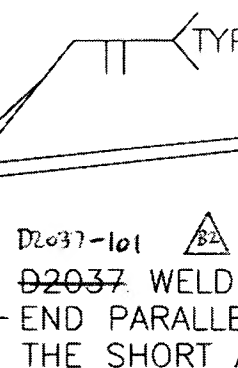
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26483 MW
12/06/29

DART



PLACE SHORTER ARM
ON SIDE OF JIG DT8065
LABELED FWD (TYP)



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
~~POWDER COAT BLACK SANDTEX (4.3.5.7) PER~~
~~DART QSI 005 4.3~~ B2

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RT	HAWKESBURY, ONTARIO, CANADA
CHECKED <u>KE</u>	APPROVED <u>RT</u>	DRAWING NO. D2161
DATE 99.06.07	TITLE MIRROR BRACKET	REV. B
A	93.04.29	NEW ISSUE
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
E1	02.03.25	CHANGE FINISH
B2	02.06.14	D2037-101 WELD
SHEET 1 OF 1		
SCALE NTS		

RELEASED
KE 99.06.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 PARTS LIST

REFERENCE ONLY

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D3439-101	MIRROR (WAS D2011-103)
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		8	MS20426AD3-4	RIVET, COUNTERSUNK
		4	D4164-041	NUT PLATE ASSEMBLY
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D3439-101 MIRROR

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Revision: **A**
Date: 10.07.20